

Date: Monday, 07/07/2008 4:15:22 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BK117 SKIDTUBE ASSEMBLY
Job Number : 40332	
Estimate Number : 12899	
P.O. Number :	Part Number : D117762011
This Issue : 07/07/2008 S.O. No. :	Drawing Number : N/A PRELIM <i>RE</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : A PRELIM <i>RE</i>
Previous Run : 38987	Material :
Written By :	Due Date : 18/07/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 08.7.07</u>	
Comment : Est Rev:A 07.06.11 New Issue EC Est Rev:B 08-02-22 change to revA DD verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JUD 08.7.24

**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D117-762-011 CHG001

S 08/08/25

2.0	40332A	BK117 SKIDTUBE ASSEMBLY
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**Comment:** Sub-Component BK117 SKIDTUBE ASSEMBLY1 x D117-762-041 Batch: *40332*

SL

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D35121	Wearplate
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WEARPLATE

Batch: *39020*

JS 08/07/10 (XU)

5.0	AN960JD10L	Washer
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**Comment:** Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Batch: *M104885*

JS 08/07/10 (XU)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40332

Part Number: D117762011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN3C4A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

BATCH: M108568 New Batch. JS 08/07/10 (X)

7.0

AN451A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

BATCH: 108077 JS 08/07/10 (X)

8.0

D2972

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bushing

BATCH: B14103 JS 08/07/10 (X)

9.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

BATCH: M107478 JS 08/07/10 (X)

10.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS JS 08/08/05

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D117-762-011

Location:

PPP Rev: Draft JS 08/08/05 SC

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE JS 08/08/26

Job Completion



40332A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Date: Monday, 07/07/2008 4:15:58 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BK117 SKIDTUBE ASSEMBLY
Job Number :	40332A		
Estimate Number :	12898		
P.O. Number :		Part Number :	D117762041
This Issue :	07/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3582 REVA PRELIM <i>BE</i>
First Issue :	/ /	Project Number :	N/A
Previous Run :	38987A	Drawing Revision :	A PRELIM <i>BE</i>
	Type :	Material :	
	SKIDTUBES	Due Date :	18/07/2008
Written By :		Qty:	1
Checked & Approved By :	<i>JUL 08-7-07</i>	Um:	Each
Comment :	Est Rev:A 07.06.11 New Issue EC Prototype for engineering use only (LG0005-32910) Est Rev:B 08-02-22 change to revA as per dwg DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D117-762-041 CHG001 *N/A*

2.0	D2962150	3.540 Outer Tube, Extrud
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2962-150 Extrusion *B28622*

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Do not open holes.

3- Deburr holes.

4.0	BENDING	BENDING MACHINE-- SKIDTUBES
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Comment: BENDING MACHINE

Bend tube as per program on CNC Bender and Dwg D3582. Use 5/16" locator pin on buggy "A". *DP 8-7-10*

W/O:		WORK ORDER CHANGES					
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40332A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Cut Fwd end of the tube using DT8185 ✓
- 2-Cut Aft end at VC using DT8185 ✓
- 3-Deburr ends ✓
- 4-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE*** ✓
- 5-Locate DT 8973 & Drill Ground wire hole on top of Tube. ✓
- 6-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill. ✓
- 7-Drill pilot holes for wearplates using DT8974
- 8-Open wearplate holes and ground wire holes to Ø19/64" (0.297") as per Dwg D3582.
- 9-Open Aft Cap holes using .209" drill. ✓
- 10-Deburr holes. ✓

DS
8-8-14

6.0

D2964

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B14101

BE 08/07/14

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld fwd cap D2964 per dwg D3582 and QSI 004

A/R AL ROD

Batch: m108076

m107877

BE 08/07/14

2-Grind flush

8-7-15

W/O:		WORK ORDER CHANGES					
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40332A

Part Number: D117762041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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8.0	QC10	VISUAL INSPECTION OF GROUND WELDS
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Comment: VISUAL INSPECTION OF GROUND WELDS

08-08-14

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08-08-14

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

ALUM 8-8-14

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 8-8-15

12.0	D2971	Cross Bolt Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

** Cross Bolt Spacer batch 39011 SL 8-8-18*

13.0	D2973	Cross Bolt Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

** Cross Bolt Spacer Batch: 14636 SL 8-8-18*

14.0	D36621	Crossbolt Spacer
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

** SPACER batch 39585 SL 8-8-18*

15.0	D36623	Crossbolt Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

** SPACER batch 37190 SL 8-8-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40332A

Part Number: D117762041

Job Number:



Seq. #:

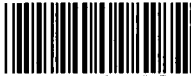
Machine Or Operation:

Description :

16.0

D35841

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEB B 40362

Q H 7-7-15

17.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open X-Bolt holes to .750"(4Places) as per Dwg D3582, section B-B

2-Counter Sink X-BOLT holes as per Dwg D3582

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3582 & QSI 015

A/R 241 Sike Flex Batch: M107801

Exp Date: 8-10-1

5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B.

A/R AL ROD Batch: M108026

BE 08/08/19

6-Grind welds flush

SL 8-8-19

H 7-7-15

Tools: E

18.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/08/20 (E)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/20 (E)

20.0

POWDER COATING

POWDER COATING



M108523



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Pressure wash - FZ 08/08/20 (E)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00
320
1:35

M-F 08/08/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40332A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-21

(X) 1

22.0

ALS41032130

Insert



Comment: Qty.: 36.0000 Each(s)/Unit Total : 36.0000 Each(s)

Insert

Batch: m105819

FL

23.0

ALS4428165

Inserts



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inserts

batch m6989

***same as ALS7-428-165 QSI 0017 ***

FL

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Wearplate & Ground Wire inserts as per Dwg D3582.

FL 08/08/21 (P)

25.0

D2965

Cap, 105 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: 641523

FL

26.0

D35083

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: 638527

FL

27.0

D35089

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: 640359

FL 08/08/21 (P)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40332A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D350811

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Batch:

B38415

WEARPLATE

FL

29.0

D350813

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch:

B38528

FL

30.0

D35583

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B38613

FL

31.0

D35589

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B36420

FL

32.0

D355811

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B36419

FL

33.0

D355813

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B40400

FL

34.0

AN3C4A

BOLT



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

BOLT

Batch:

M108599

FL 08/08/21 (P)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40332A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN3C5A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: m108744

FL

36.0

AN44A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch m106918

FL

37.0

AN960C10L

washer



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

washer

Batch: m108618

FL

38.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch m104885

FL

39.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch m108583

FL

40.0

D3492049

Plug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PLUG ASSEMBLY

batch D40356

FL

41.0

D3492051

Plug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PLUG ASSEMBLY

batch D59723

FL

08/08/21 (13)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40332A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

D3492053

Plug Assembly



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

PLUG ASSEMBLY

batch

1540357

FL

43.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign objects

2-Install Aft cap as per Dwg D3582, Detail "C"

A/R 241 Sika Flex

Batch:

m108801

Exp Date:

08/10

3-Install Wearplates as per Dwg D3582 ,

Note:Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582

*****Do not install bolts where indicated on Dwg(Note #6)*****

A/R 241 Sika Flex

Batch:

m108801

Exp Date:

08/10

FL
08/08/21

4- Wing Walk as per Dwg D3043 and QSI 005 4.4

m108496 - FL 08/08/22

①

44.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/25

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D117-762-041

Location:

PPP Rev:

PPP

8/8/25

SY

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

Job Completion



U 08.08.26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

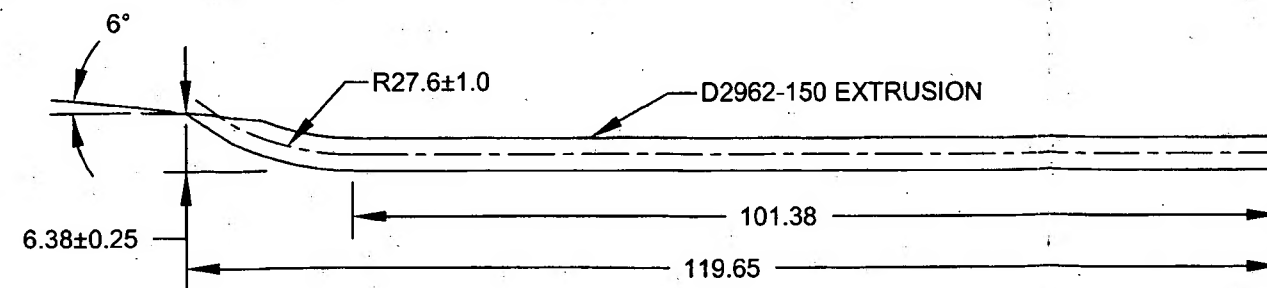
NOTE: Date & initial all entries

PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

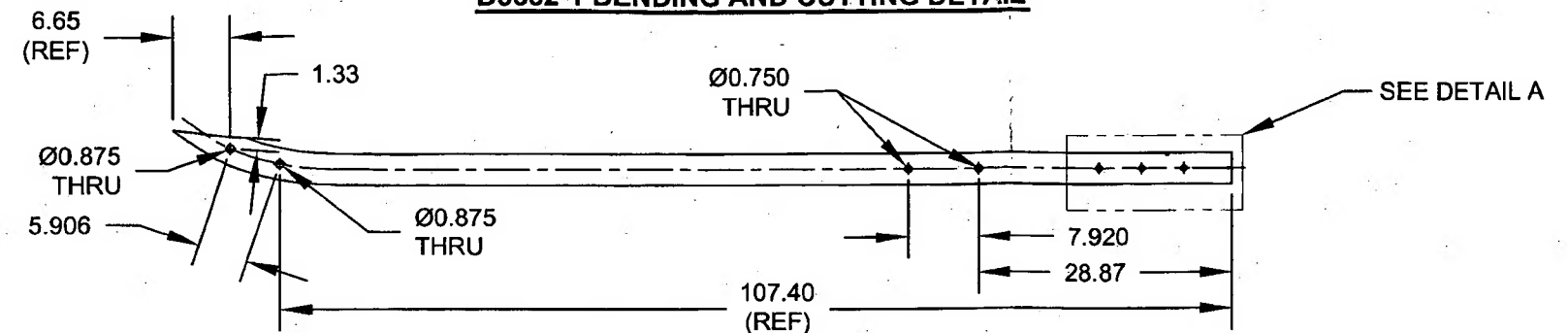
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

GENERAL NOTES:

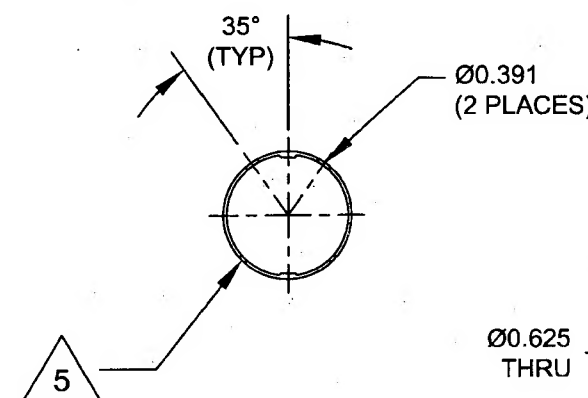
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004.
- INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- FINISH:
 - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
 - POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 - ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4



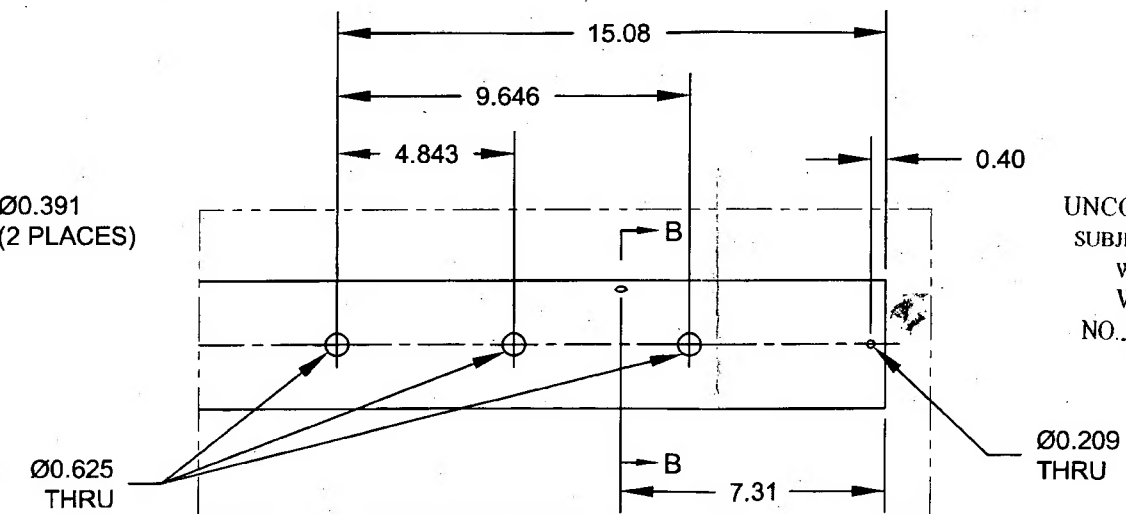
D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B
SCALE 1:5

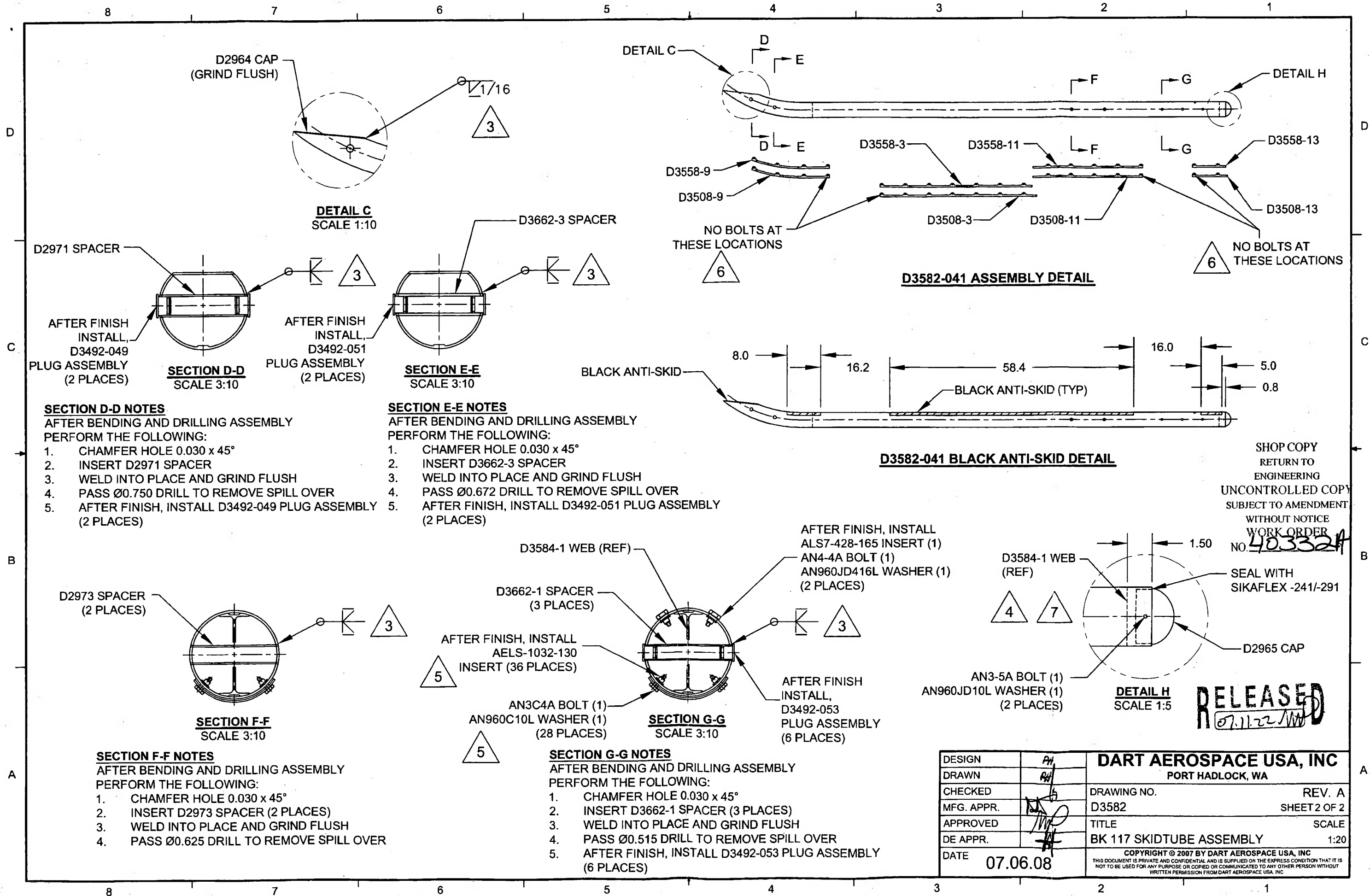


DETAIL A
SCALE 1:5

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07.11.22

A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3582	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	BK 117 SKIDTUBE ASSEMBLY	1:20
DATE	07.06.08	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



NO. 148

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 38384A
Part number: D117 762 041
Description: Skid tube Bk117
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pet Duval Date of Test Coupon 08-04-14
Welder Barclay Elliot Date of Test Coupon 08-04-14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld